

Work Order ID 164050

164050

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Wednesday, July 12, 2017 1:03:53 PM

Item ID: D350-567-145 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Floor Window Close Out (AS350 B3e)
 Start Date: 7/12/2017 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 7/17/2017 Req'd Qty: 1.00 ***1*** Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSI 9590	F								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D350-567-145 CHG001								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.03							
Quality Control									

DAS
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JUL 18 2017

DAS
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Item ID: D350-567-145

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Floor Window Close Out (AS350 B3e)

Start Date: 7/12/2017 Start Qty: 1.00

1

Cust Item ID:

Required Date: 7/17/2017 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Packaging	Identify as per dwg & Stock Location: _____ Packaging Memo Identify and pack for shipping as per PPP D350-567-145 Location:FG033 Sold	0.00 0.00							
						DAS 28 9-89 JUL 18 2017			
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.10							
						DAS 21 9-89 JUL 19 2017			
						 JUL 19 2017			

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D350-567-145

Required Qty: 1.00

Comments: IPP REV:A 13.04.01 AS PER DSI9590 REV.E DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
CB200 *CB200* Acrylic Adhesive, 3.5G		Purchased	No			110	Each	19.0000	0	1			
DAS 28 9-89 1/08/2018 <u>Location</u> PKG m136020 m136918 m136932 <u>Loc Qty</u> 19 1 4 14 <u>Loc Code</u>													
D4730-020-030 *D4730-020-030* Velcro Strip 2.00 DAS.0L		Manufactured	No			110	Each	9.0000	1	1			
DAS 28 9-89 <u>Location</u> ST122 163668 <u>Loc Qty</u> 9 9 <u>Loc Code</u>													
D4971-041 *D4971-041* T/R Bellcrank Cover Assembly		Manufactured	No			110	Each	4.0000	0	1			
DAS 28 9-89 <u>Location</u> ST621 162712 <u>Loc Qty</u> 4 4 <u>Loc Code</u>													
D5076-041 *D5076-041* Fwd Bracket Assembly		Manufactured	No			110	Each	0.0000	0	1			
DAS 28 9-89 <u>Location</u> <u>Loc Qty</u> <u>Loc Code</u> 163403													

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Parent Item: D350-567-145

D350-567-145

Parent Item Name: Floor Window Close Out (AS350 B3e)

Start Date: 7/12/2017

Required Date: 7/17/2017

Start Qty: 1.00

Required Qty: 1.00

D3802-1 Manufactured No

110 f

31.7978

2 2

D3802-1

Window Seal (\$ per foot)

DAS
38
28
9-89

Location

Loc Qty

Loc Code

ST416

31.79775453

156349

0.00275453

160123

31.795

(D3802-1-024) CUT (1) AT 24" AS PER DWG, PER KIT.

D4435-9 Manufactured No

110 Each

5.0000

2 2

D4435-9

Bracket

DAS
28
9-89

Location

Loc Qty

Loc Code

ST098

5

162714

5

D4436-041 Manufactured No

110 Each

0.0000

1 1

D4436-041

Aft Bracket Assembly

D4441-1 9-89

Manufactured No

110 f

264.0512

2 2

D4441-1

Rubber Seal

DAS
38
28
9-89

Location

Loc Qty

Loc Code

ST422

18.2392

151347

18.2392

ST625

245.812

151347

245.812

(D4441-1-240) CUT (1) AT 24.00" PER KIT

**

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Parent Item: D350-567-145

D350-567-145

Parent Item Name: Floor Window Close Out (AS350 B3e)

Start Date: 7/12/2017

Required Date: 7/17/2017

Start Qty: 1.00

Required Qty: 1.00

AN3-3A Purchased No

AN3-3A

Bolt

DAS
28
9-89

Location

Loc Qty

Loc Code

ST350

88

m137597

38

m137853

50

110 Each

88.0000

5 5

**

DAS 6 DAS 27
JUL 18 2017 9-89 9-89

AN525-10R6 Purchased No

AN525-10R6

Screw

DAS
28
9-89

Location

Loc Qty

Loc Code

ST329

348

M137307

348

110 Each

348.0000

2 2

**

DAS 6 DAS 27
JUL 18 2017 9-89 9-89

AN525-832R7 Purchased No

AN525-832R7

Screw

DAS
28
9-89

Location

Loc Qty

Loc Code

ST328

75

m136983

75

110 Each

75.0000

2 2

**

DAS 6 DAS 27
JUL 18 2017 9-89 9-89

MS21042L06 Purchased No

MS21042L06

Nut

DAS
28
9-89

Location

Loc Qty

Loc Code

ST303

193

m137391

93

m137851

100

110 Each

193.0000

7 7

**

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JUL 18 2017 9-89 9-89

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Parent Item: D350-567-145

D350-567-145

Parent Item Name: Floor Window Close Out (AS350 B3e)

Start Date: 7/12/2017

Required Date: 7/17/2017

Start Qty: 1.00

Required Qty: 1.00

MS21042L08

Purchased

No

110

Each

894.0000

2 2

MS21042L08

Nut

DAS
28
9-89

Location

Loc Qty

Loc Code

GA	100	
m135274	6	
m135978	94	
ST303	794	
m137391	150	
m137464	94	2
m137736	250	
m137851	100	
m137951	200	

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MS21042L3

Purchased

No

110

Each

1,321.000

5 5

MS21042L3

Nut

DAS
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9-89

Location

Loc Qty

Loc Code

FP001	79	
m135945	79	
GA	378	
m134360	102	
M136665	276	
OVER007	500	
m137988	500	
ST303	364	
m137680	64	
m137886	300	5

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Parent Item: D350-567-145

D350-567-145

Parent Item Name: Floor Window Close Out (AS350 B3e)

Start Date: 7/12/2017

Required Date: 7/17/2017

Start Qty: 1.00

Required Qty: 1.00

MS21059L3

Purchased No

110

Each

180.0000

2 2

MS21059L3

Nut Plate

DAS
28
9-89

Location

Loc Qty

Loc Code

GA	83	
M137412	3	
M137659	30	
M137710	50	
ST301	97	
M137587	4	
M137820	43	
M137963	50	

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DAS
6
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DAS
27
9-89

MS35206-229

Purchased No

110

Each

158.0000

7 7

MS35206-229

Screw

DAS
28
9-89

Location

Loc Qty

Loc Code

ST271	158	
M135603	158	

JUL 18 2017

DAS
6
9-89

DAS
27
9-89

NAS1149F0332P

Purchased No

110

Each

1,710.000

10 10

NAS1149F0332P

Washer

DAS
28
9-89

Location

Loc Qty

Loc Code

GA	275	
m133709	275	
ST262	1435	
m137710	1435	

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Picklist Print

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Parent Item: D350-567-145

D350-567-145

Parent Item Name: Floor Window Close Out (AS350 B3e)

Start Date: 7/12/2017

Required Date: 7/17/2017

Start Qty: 1.00

Required Qty: 1.00

NAS1149FN616P

Purchased

No

110

Each

108.0000

14

14

NAS1149FN616P

WASHER

DAS
28
9-89

Location

Loc Qty

Loc Code

ST264

108

M137061

8

M137851

100

110

Each

352.0000

2

2

NAS1149FN816P

Purchased

No

NAS1149FN816P

WASHER

DAS
28
9-89

Location

Loc Qty

Loc Code

ST263

352

117316

352

**

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REFERENCE ONLY

2.0 Parts List

Qty -141	Qty -143	Qty -145	Part Number	Description
X			D350-567-141	FLOOR WINDOW CLOSE-OUT KIT (REGULAR SEATS)
	X		D350-567-143	FLOOR WINDOW CLOSE-OUT KIT (ENERGY ATTENUATING SEATS)
		X	D350-567-145	FLOOR WINDOW CLOSE-OUT KIT (AS 350 B3e)
1	1	1	D3802-1-024	SEAL (24")
1	1		D4434-041	FWD BRACKET ASSEMBLY
1	1		D4434-047	COVER ASSEMBLY
1			D4435-045	T/R BELLCRANK COVER ASSEMBLY
2	2	2	D4435-9	BRACKET
1	1	1	D4436-041	AFT BRACKET ASSEMBLY
1	1	1	D4441-1-240	RUBBER SEAL (24")
		1	D4730-020-030	VELCRO STRIP
	1	1	D4971-041	T/R BELLCRANK COVER ASSEMBLY
		1	D5076-041	FWD BRACKET ASSEMBLY
7	5	5	AN3-3A	BOLT
2	2	2	AN525-10R6	SCREW
2	2	2	AN525-832R7	SCREW
		1	CB 200	3.5g ACRYLIC ADHESIVE
7	7	7	MS21042L06	NUT (OR MS21042-06)
2	2	2	MS21042L08	NUT (OR MS21042-08)
5	5	5	MS21042L3	NUT (OR MS21042-3)
2	2	2	MS21059L3	NUTPLATE
7	7	7	MS35206-229	SCREW
12	10	10	NAS1149F0332P	WASHER (AN960-10L)
14	14	14	NAS1149FN616P	WASHER (OR AN960-6L)
2	2	2	NAS1149FN816P	WASHER (OR AN960-8L)

3.0 Weight and Balance

The following is the net weight increase associated with the D350-567-141/-143/-145 Kits.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-567-141/-143/-145	3.9 lb	17.9 in	69.8 in-lb	65.5 in	255.5 in-lb
Floor Window Close-out Kit	1.77 kg	0.45 m	0.80 m-k	1.66 m	2.94 m-k

4.0 Installation Procedure

Notes:

- Figure 2 shows the general arrangement and installation of the D350-567-141/-143/-145 Close-out Kits. The procedure that follows outlines the step-by-step procedures for installing the kit with reference photos from the initial installation.
- In conjunction with this modification, it is acceptable to remove the interior floor windows as applicable. Note that the structural reinforcement around the window opening is still required.
 - D350-567-115 - OK to remove D3295-041
 - D350-567-031 - OK to remove D3212-1
 - D350-567-011 - OK to remove D2214
 - D350-567-021 - OK to remove D2951
- It is acceptable to drill/trim the D350-567-141/-143/-145 Close-out Kits as required to improve fit.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 15.01.12
CERT. NO.: SH92-18
ISSUE NO.: 6

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	N/A	DSI 9590	SHEET 2 OF 19
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	FLOOR WINDOW CLOSE-OUT KIT	NTS
DATE	15.01.12	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

164050

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N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 7/12/2017 **Start Qty:** 1.00 *** 1 ***

Cust Item ID:

Required Date: 7/17/2017 **Req'd Qty:** 1.00 *** 1 ***

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
DSI 9590	F

100	Document Control	0.00
100	DOCUMENT CONTROL	
DC	Memo	0.00
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D350-567-145	CHG001

DAS
5
9-89

JUL 19 2017

110	Pick Kit	0.00
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110		
Packaging	Memo	0.00

Packaging

DAS 6
 JUL 1 1977
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QC4- 100% Inspect kits for completeness	0.00
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120		
QC	Memo	0.03

Quality Control

DAS
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9-89



Transport
Canada

Transports
Canada

Department of Transport

Supplemental Type Certificate

This approval is issued to:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ontario
Canada K6A 1K7

Number: SH92-18

Issue No.: 6

Approval Date: April 21, 1992

Issue Date: February 04, 2009

Responsible Office:

Ontario

Aircraft/Engine Type or Model:

EUROCOPTER FRANCE AS 350 BA, AS 350B, AS 350B1, AS 350B2, AS 350B3, AS 350D, AS 350D1, AS 355 E, AS 355 F, AS 355 F1, AS 355 F2, AS 355 N, AS 355 NP

Canadian Type Certificate or Equivalent:

EUROCOPTER FRANCE AS 350 BA, AS 350B, AS 350B1, AS 350B2, AS 350B3, AS 350B3, AS 350D, AS 350D1, H-83
EUROCOPTER FRANCE AS 355 E, AS 355 F, AS 355 F1, AS 355 F2, AS 355 N, AS 355 NP H-87

Description of Type Design Change:

Installation of vertical reference (floor) window.

Installation/Operating Data:

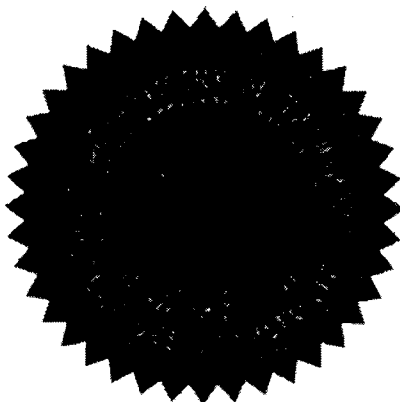
Required Equipment and Limitations:

Manufacturing must be accordance with Dart Aerospace Ltd. Master Drawing List MDL-D350-567, Revision A dated January 23, 2009 or later TC approved revision.

Installation must be in accordance with Dart Aerospace Installation Instructions D350-567, Revision D, dated July 8, 2008 or later TC approved revision.

Maintenance must be in accordance with Dart Aerospace Instructions for Continued Airworthiness, ICA-D350-567, Rev 0 dated January 20, 2009 or later TC accepted revision is required.

- END -



Conditions: This approval is only applicable to the type/model of aeronautical product specified therein. Prior to incorporating this modification, the installer shall establish that the interrelationship between this change and any other modification(s) incorporated **will not** adversely affect the airworthiness of the modified product.


M. Mariotti
For Minister of Transport

Canada